

Date: Friday, 25/07/2008 11:32:35 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY KIT	
Job Number :	40757			
Estimate Number :	13504			
P.O. Number :		Part Number :	K10019	
This Issue :	25/07/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	N/A	
First Issue :	//	Project Number :	N/A	
Previous Run :		Drawing Revision :	N/A	
	Type :	Material :		
	SMALL /MED FAB	Due Date :	25/08/2008	Qty: 1 Um: Each
Written By :				
Checked & Approved By :	JD 08.7.25			
Comment :	Est: A 08.07.24 new issue EC verified by DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D21951	Bracket
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40763



scf

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Bracket

2.0	D21952	Bracket
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B40761



scf

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Bracket

3.0	D21953	Spacer
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B40762



scf

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Spacer

4.0	D21961	Bracket
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19154



scf

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Bracket

5.0	D21962	Bracket
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19154



scf

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Bracket

6.0	D21963	Spacer
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B40830



(X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Spacer

8/11/7

scf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 11:32:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY KIT

Job Number: 40757

Part Number: K10019

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D21971

Bracket



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket

19154 40766

SP

8.0

D21972

Bracket



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket

19154 40767

SP

9.0

D21973

Spacer



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacer

B40833

10.0

MS20470AD414

Rivet



(X)

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Rivet

M1046

8/11/7

SP

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2195-1/-2/-3 using MS20470AD4-14 rivet

Assemble D2196-1/-2/-3 using MS20470AD4-14 rivet

Assemble D2197-1/-2/-3 using MS20470AD4-14 rivet

081110

SP

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-10

13.0

POWDER COATING

POWDER COATING



(X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50
320 OF
8:20

M. 08/11/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

*****Powder Coat D2195, D2196, D2197*****

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



90



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-12

15.0

D31911

Backer Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Backer Plate

3409 83

90

081110

16.0

D31913

Backer Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Backer Plate

3409 84

90

0811 10

17.0

D21981

Bracket



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket

3407 89

90

0811 10

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K10019

Location: _____

PPP Rev: _____

B

90

081124

Job Completion



mf 08-11-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries